

Surface (Reciprocating) Grinding

Material Ground	Abrasive Type	Parameters			
		Wheel peripheral Speed	Cross feed	Work piece Traverse speed	Depth of Cut
Carbide	Diamond	.m/sec 20...30 SFM 4,000...6,000	Approx. ½ Of Wheel width/stroke	.m/min. 5....15 .inch/min. 200...400	.018mm .0007 inches
Hardened Steel	CBN	.m/sec 25...40 SFM 5,000..8,000	Approx. ½ Of Wheel width/stroke	.m/min. 10....20 .inch/min 400..800	.018mm .0007 inches

Depth of Cut Calculation 20% of FEPA Grit Size

150 mesh = FEPA 91 (.091mm)
.091x 20% = .018mm - .0007 inches

Suggested Mesh size and Concentration

ASD 150 R75 B
CBN 150 R75 B